

Work Order ID 80331

80331

Page 1

February-17-12 8:28:45 AM

Item ID: D3535-25 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 17/02/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: M L J Date: 12/02/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
 Debur if necessary
304.040
1312-2-29
 (13)

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
1312-2-29

120 0.00
 120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control
1312-2-29
 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00				(13)			
130									
Brake NC	Memo	0.00							
Brake NC	1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT83262- Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11/6/20 OVEN TEMPERATURE: FINISH TIME: 11/6/20 320°F								

M118489.

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13 BR 12-3-5

13 x 8 m/l 12/03/05

MLJ 12/03/05

12-03-5
(13)

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Picklist Print

February-17-12 8:28:50 AM

Page 1

Work Order ID: 80331

80331

Parent Item: D3535-25

D3535-25

Parent Item Name: Wearshoe

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	275.0165	0.51	6.442105			

M304S20GA

304/316 .040 Sheet

1812-2-24

Location

Loc Qty

Loc Code

MAT020

275.0165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

160

120604

(13)

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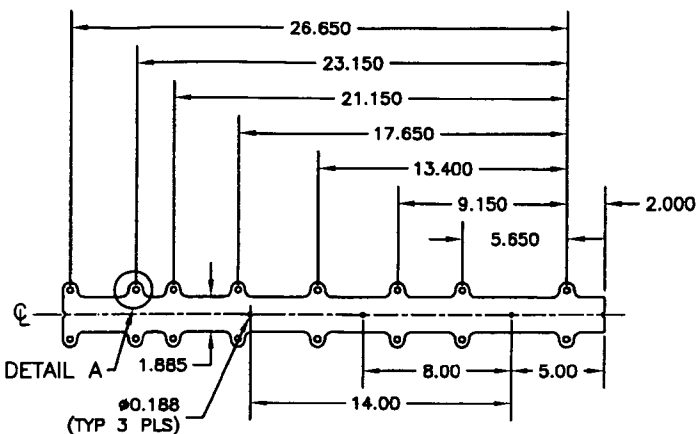
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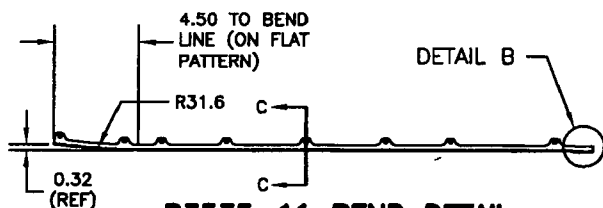
07.04.24

SHOULDER
FLAT PATTERN
UNCONFINED
STRUCTURE
W/OUT
W/

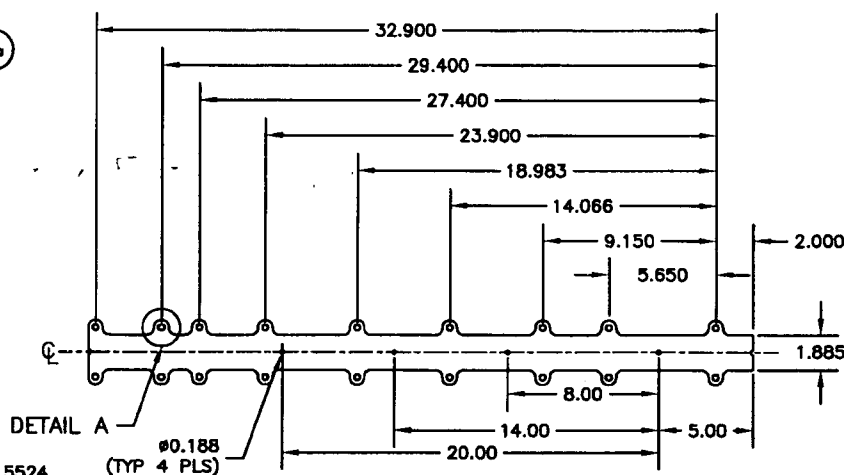
NO. 80331 M.C.J
12/02/17



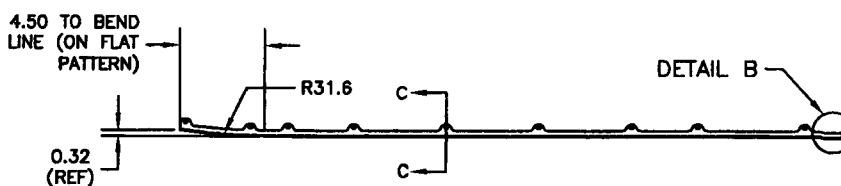
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

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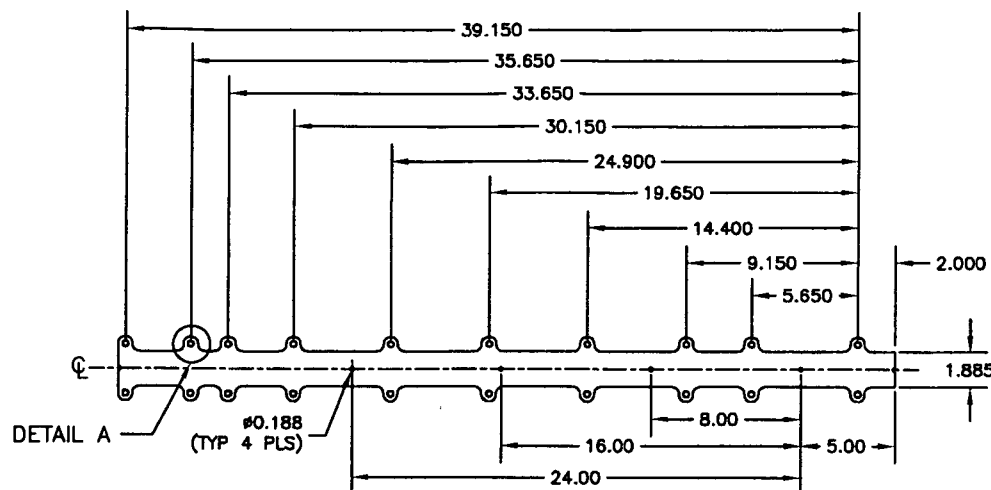
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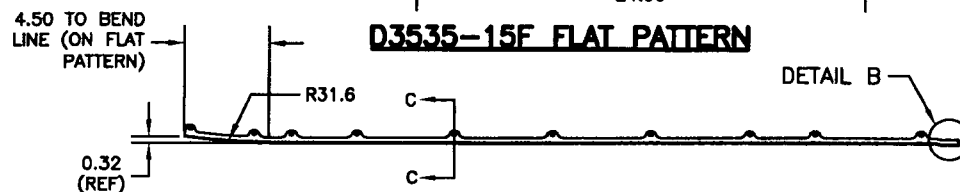
07.04.17

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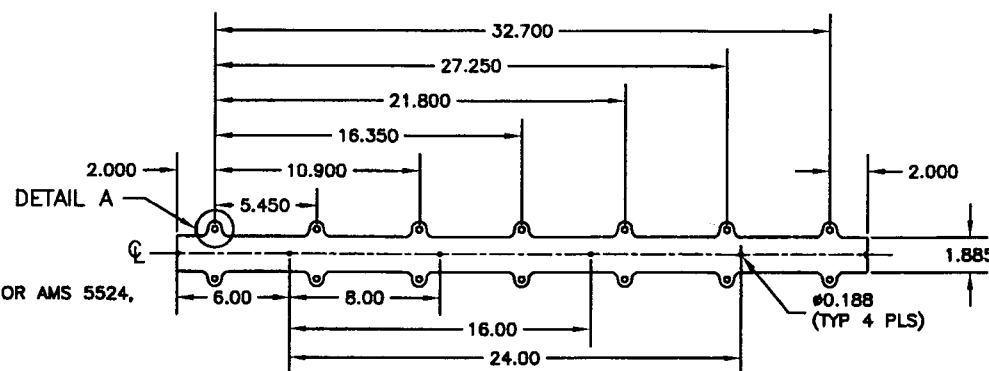
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:1	
		SHEET 2 OF 7		
		REV. B		



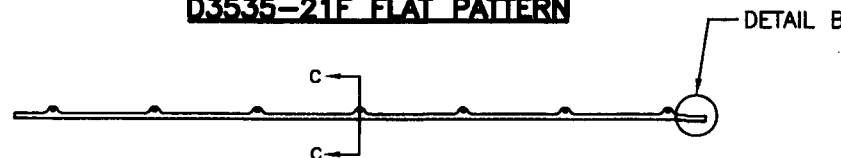
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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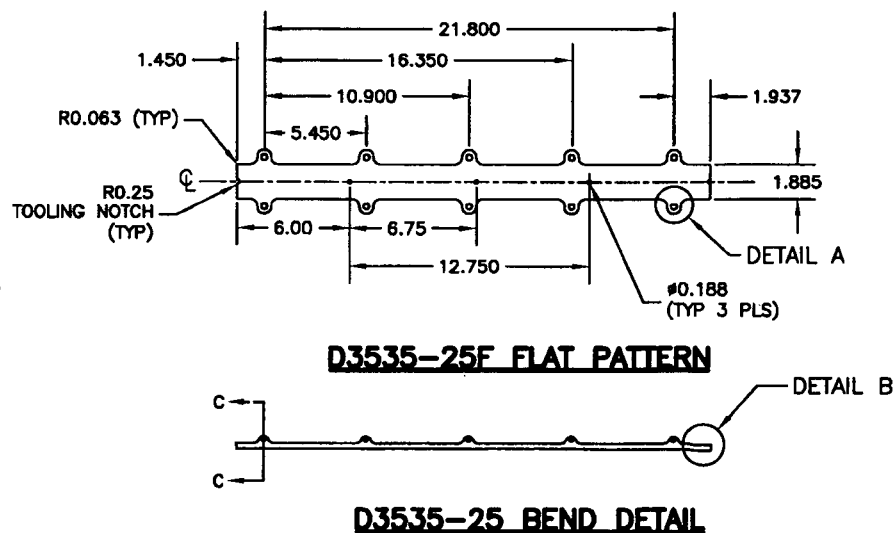
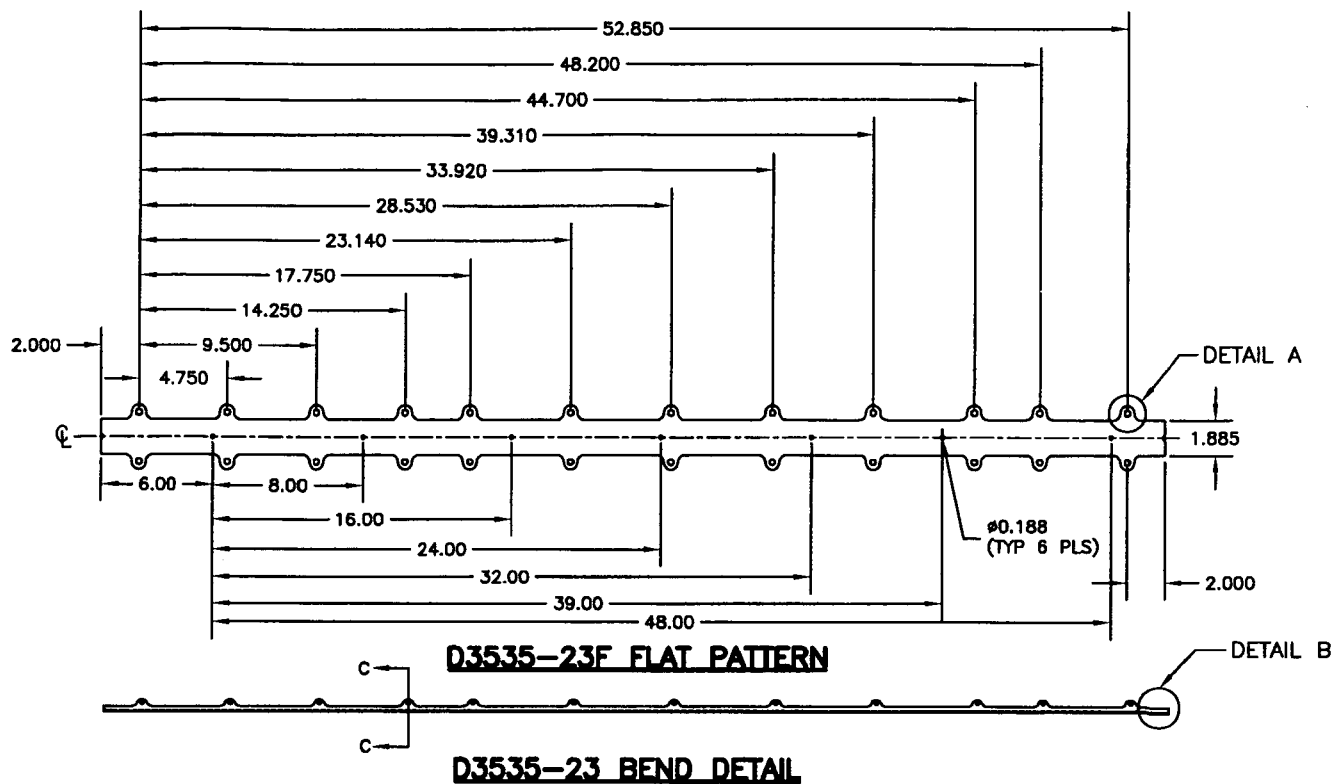
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 3 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

80331

RELEASED

07.04.24

**NOTES**

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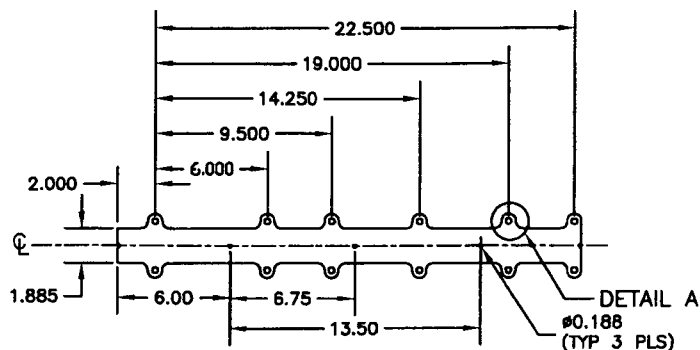
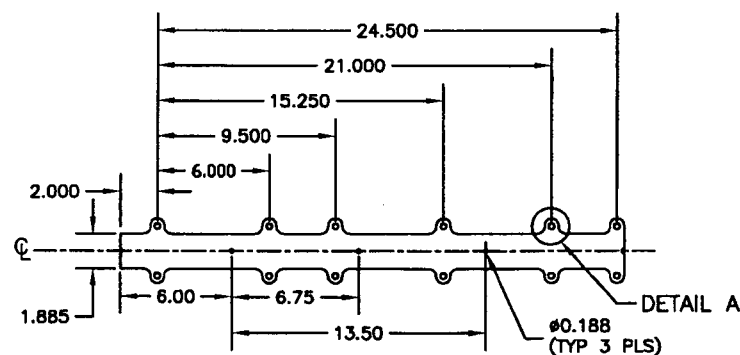
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>		SHEET 4 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	

80331

RELEASED
07.04.24**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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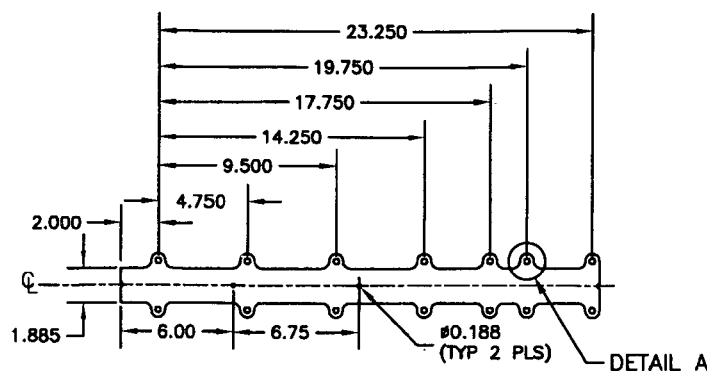
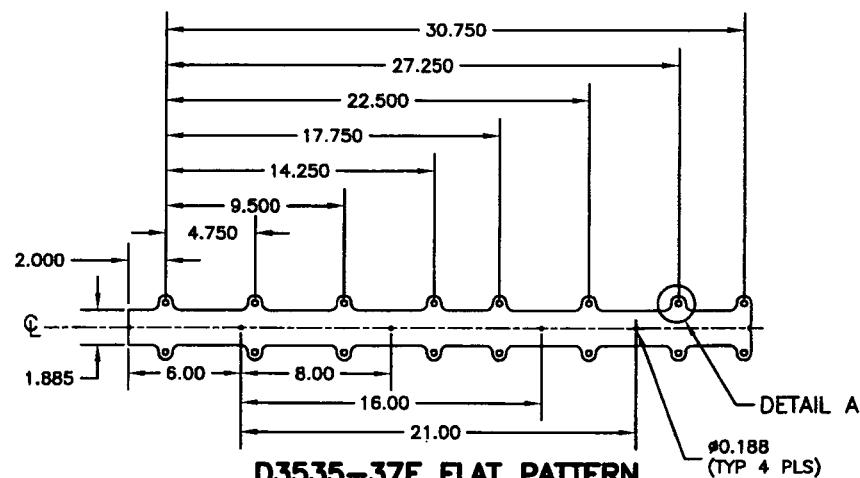
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

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		D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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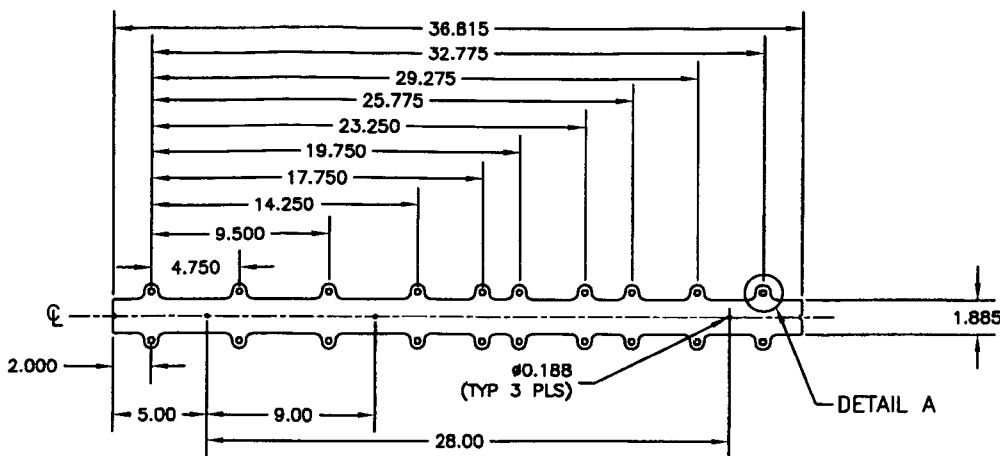
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PORT HADLOCK, WA

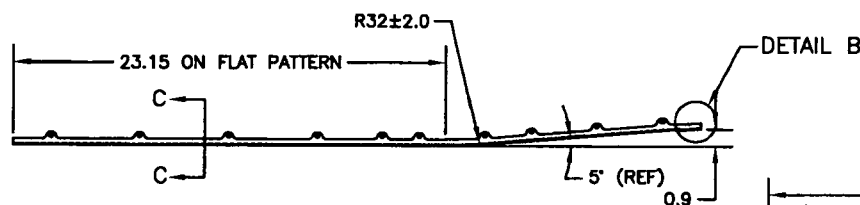
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CB	PH	D3535	SHEET 6 OF 7
CHECKED	APPROVED	TITLE	SCALE
07.04.17	WEARSHOE		1:10

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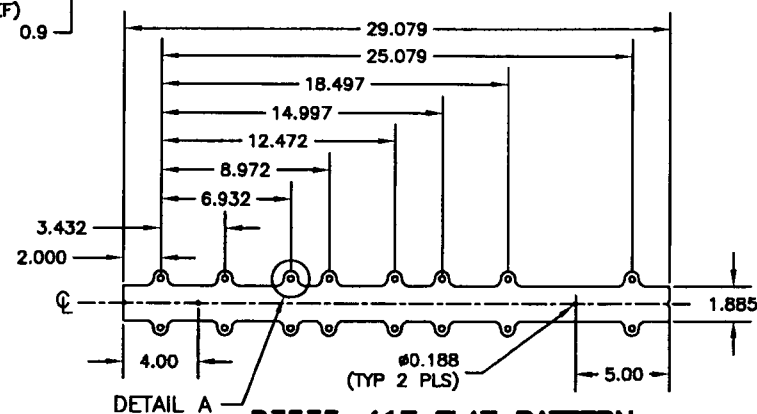
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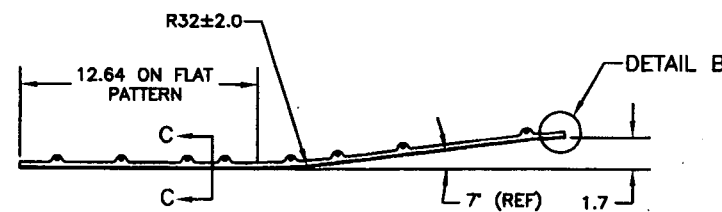
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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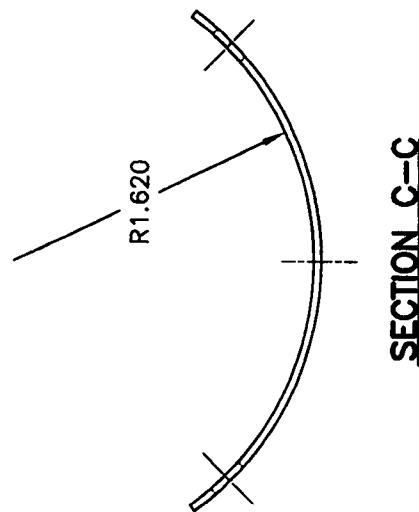
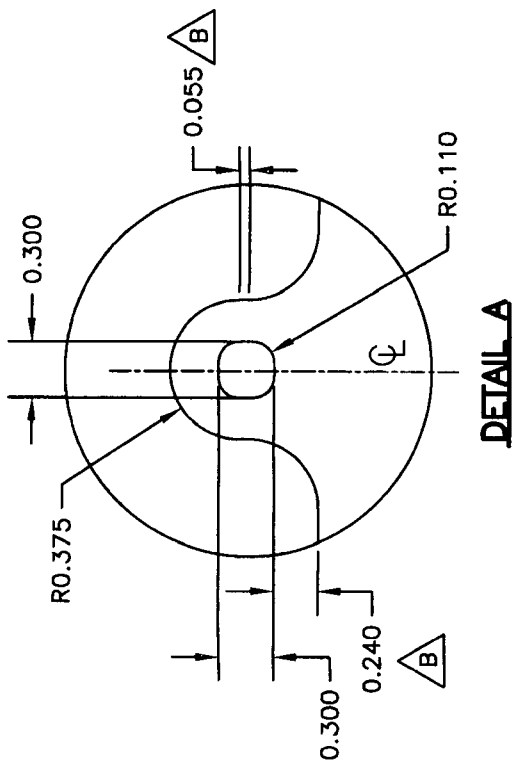
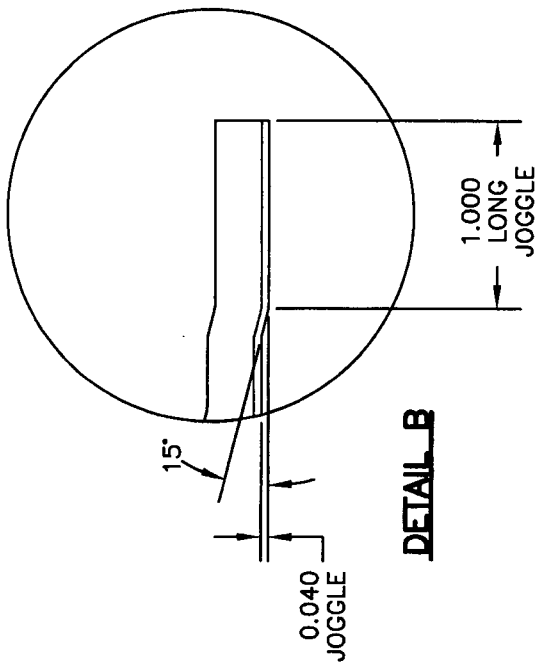


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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